

Work Order ID 54817

December 22, 2009 1:27:13 PM



Page 2

Work Order ID 54817

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Page 1

Item ID: D3694-041

Accept



Setup Start



Revision ID:

Item Name: MOUNTING PLATE

Stop



Start Date: 1/05/10 Start Qty: 2.00



Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: CL

Date: 09/12/23 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3694	Rev C

100



Small Fab

Small Fab

Memo

Small Fab

1-Install helicoils as per Dwg D3694! 2-Install Protective & Mounting plate as per Dwg D3694

0.00

110



QC5- Inspect part completeness to step on W/O

QC

Quality Control

0.00

120



Identify as per dwg & Stock Location: _____

Packaging

Packaging

0.00

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

--	--	--	--	--	--	--	--	--

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

December 22, 2009 1:27:05 PM

Page 1

Work Order ID: 54817



Parent Item: D3694-041



Parent Item Name: MOUNTING PLATE

Start Date: 1/05/10

Required Date: 1/15/10

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN526C1032R8		Purchased		No			Each	771.0000	2.0000			

Screw

Warehouse

Location

Main Warehouse

ST

9216 ✓

Loc Qty

771

Loc Code

771

m-h

10/02/11

AN960JD10



Washer

Purchased

No

Each 1,486.000 10.0000



Warehouse

Location

Main Warehouse

ST

Loc Qty

1486

Loc Code

105442	8
109059	2
109840	23
110139	2
110985	202
111279	5
111668	48
112314	174
112369	22
113149	1000

NAS1149D0363J

M113288

10X m-h 10/02/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 22, 2009 1:27:06 PM

Page 2

Work Order ID: 54817



Parent Item: D3694-041

Parent Item Name: MOUNTING PLATE

Start Date: 1/05/10

Required Date: 1/15/10

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3694-1		Manufactured	No				Each	1.0000	2.0000			

Mounting Plate

Warehouse

Location

Main Warehouse

ST



Loc Qty

1

1

Loc Code

X M-1 10/02/11

D3694-3

Manufactured

No



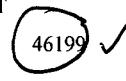
MOUNTING PLATE ASSY

Warehouse

Location

Main Warehouse

ST



Loc Qty

2

2

Loc Code

X M-1 10/02/11

D3694-5

Manufactured

No



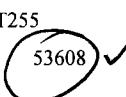
MOUNTING PLATE ASSY

Warehouse

Location

Main Warehouse

ST255



Loc Qty

10

10

Loc Code

X M-1 10/02/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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December 22, 2009 1:27:06 PM

Work Order ID: 54817



Parent Item: D3694-041



Parent Item Name: MOUNTING PLATE

Start Date: 1/05/10

Required Date: 1/15/10

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L3		Purchased		No			Each	2,372.000	8.0000			

Nut

Warehouse Loc Qty Loc Code

Location

Main Warehouse M113523

ST	2372
110844	35
111274	27
111668	64
112314	1746
112385	500

8X

m-f
10/02/11

MS21209-F120



Purchased

No

Each 44.0000 4.0000



HELI COIL

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	44
107823	44

4X

m-f
10/02/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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December 22, 2009 1:27:07 PM

Work Order ID: 54817



Parent Item: D3694-041



Parent Item Name: MOUNTING PLATE

Start Date: 1/05/10

Required Date: 1/15/10

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS24693-C271

Purchased

No

Each 5,478.000 2.0000



Screw

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST

5478

1112

3831

1139

1180

1445

266

1664

201

MS24693-C273

Purchased

No

Each 125.0000 8.0000



Screw

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST

125

107394

1

109962

24

111072

100

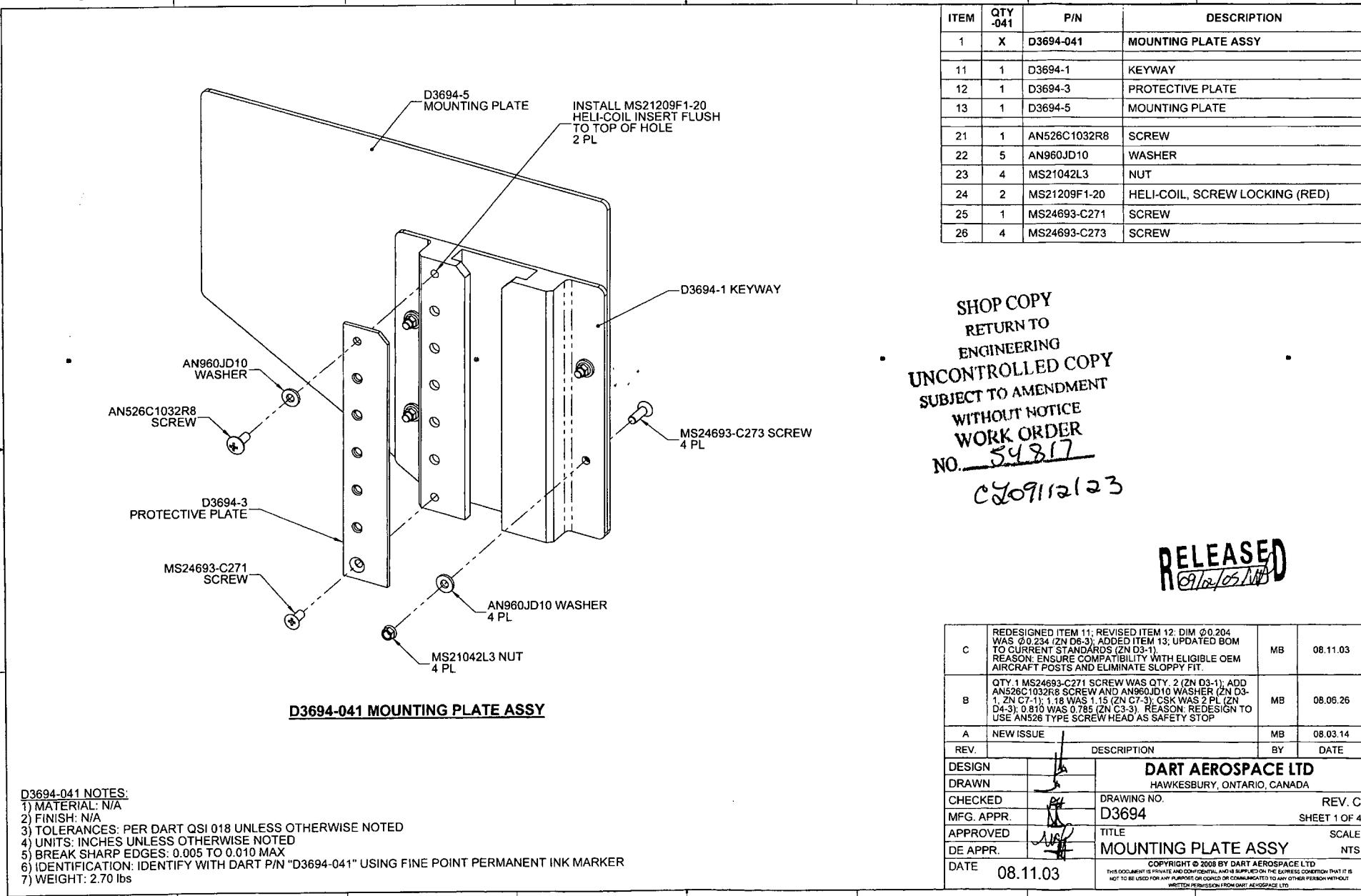
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

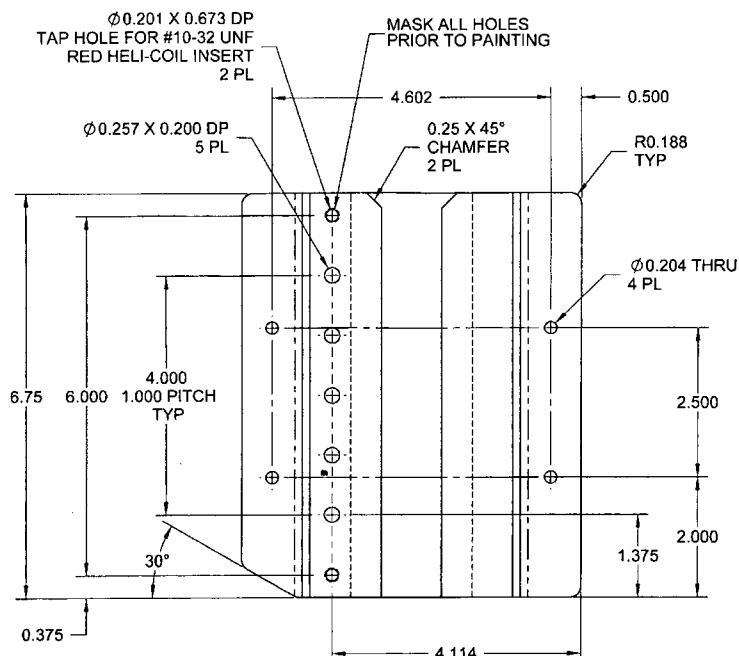
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 54817

RELEASED
09/02/05 M

D3694-1 NOTES:

1) MATERIAL: 6061-T6 (OR 6061-T651-T6510/-T6511/-T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC. M6061T6B

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (4.3.5.6) PER DART
QSI 005 4.3

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

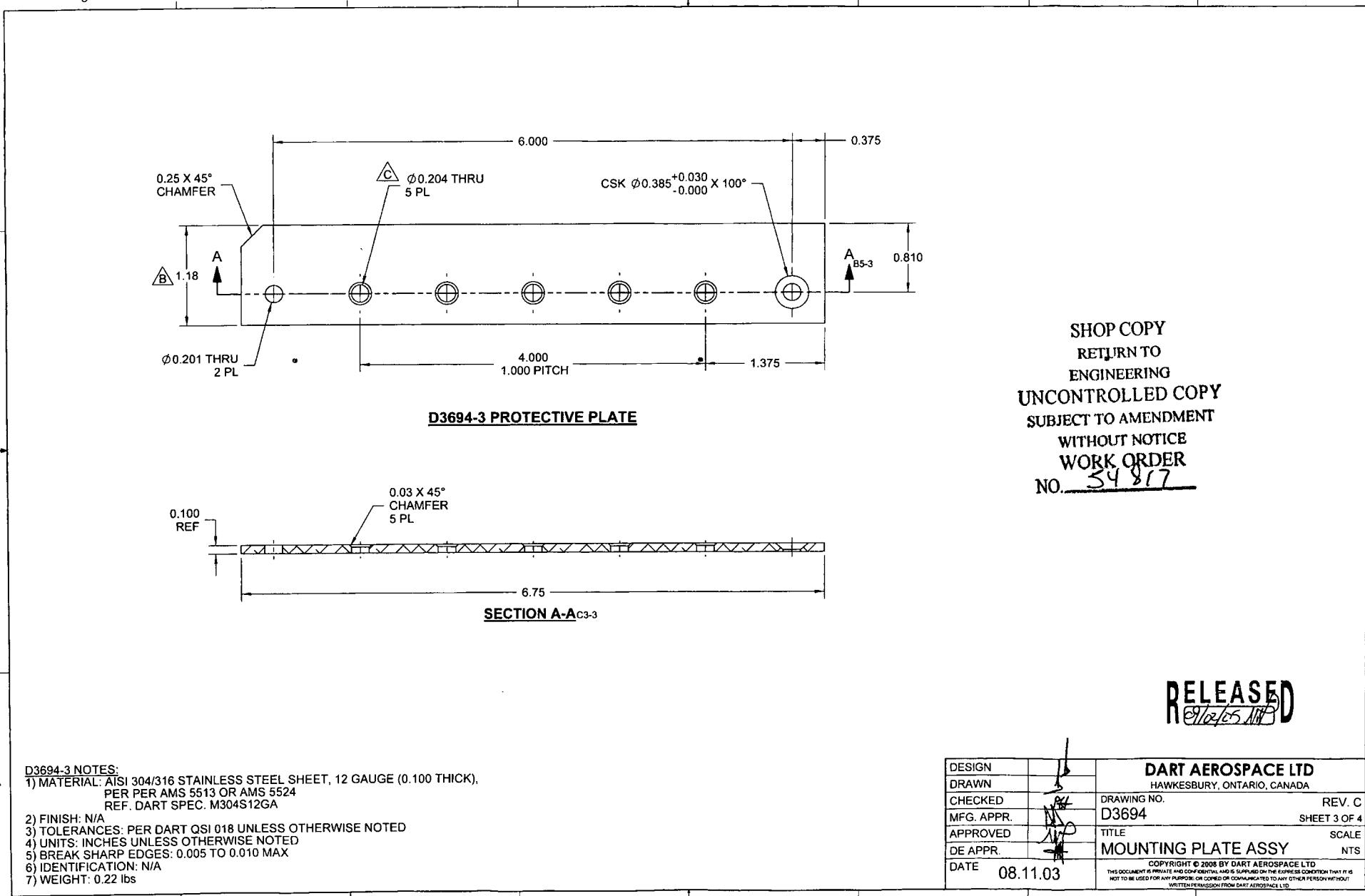
6) IDENTIFICATION: N/A

7) WEIGHT: 1.39 lbs

D3694-1 KEYWAY

DESIGN	<i>15</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	<i>5</i>			
CHECKED	<i>R4</i>	DRAWING NO.	REV. C	
MFG. APPR.	<i>MD</i>	D3694	SHEET 2 OF 4	
APPROVED	<i>MD</i>	TITLE	SCALE	
DE APPR.	<i>MD</i>	MOUNTING PLATE ASSY NTS		
DATE	08.11.03	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT CONTAINS TRADE SECRET INFORMATION WHICH IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE EXPRESS WRITTEN CONSENT OF DART AEROSPACE LTD.		

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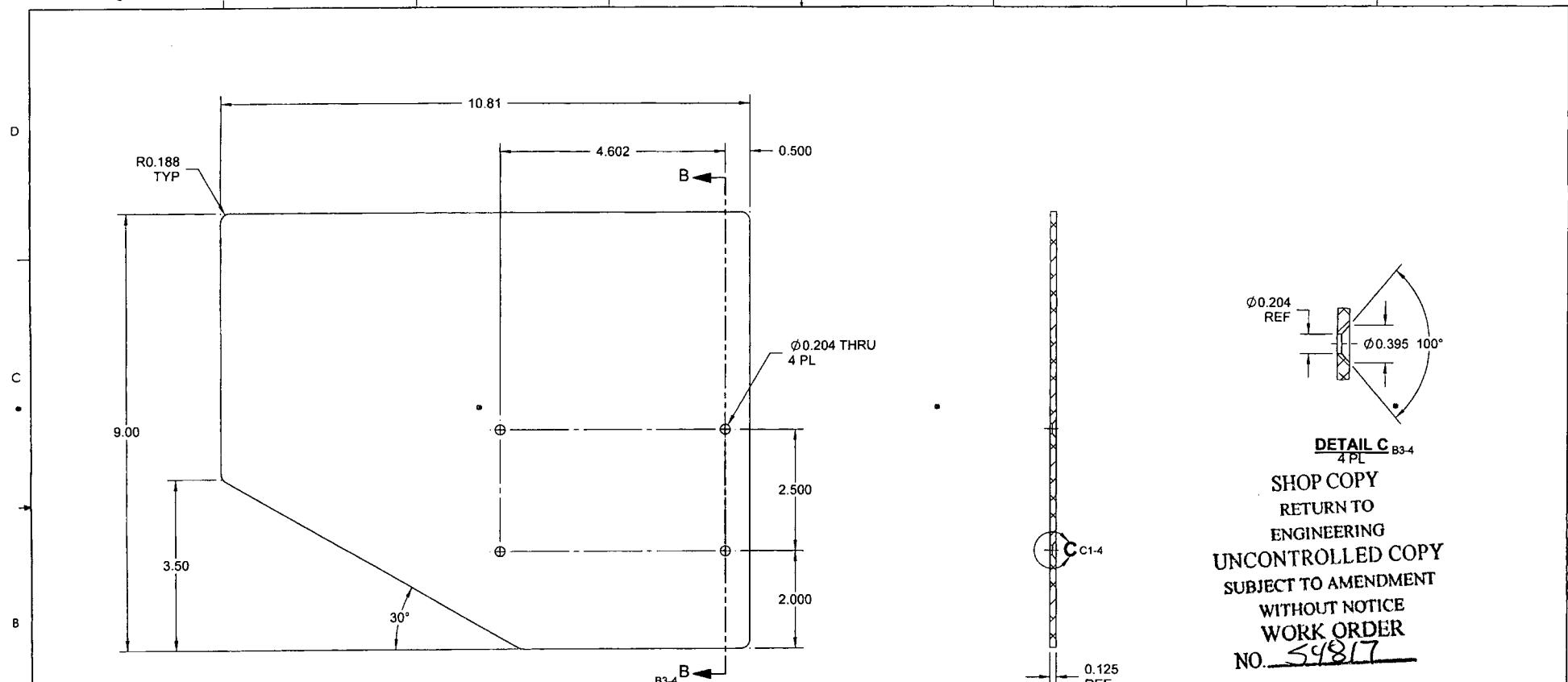
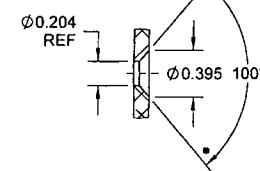


DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3694	SHEET 3 OF 4
APPROVED		TITLE	
DE APPR.		SCALE	
DATE	08.11.03	NTS	

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RELEASED
07/05/05

8 7 6 5 4 3 2 1

D3694-5 MOUNTING PLATESECTION B-B B5-4

DETAIL C B3-4
 SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 54817

RELEASED
9/6/05 JMB

D3694-5 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR OR AMS 4027 REF. DART SPEC. M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.08 lbs

DESIGN	<u>1</u>	DART AEROSPACE LTD	
DRAWN	<u>1</u>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>1</u>	DRAWING NO.	
MFG. APPR.	<u>1</u>	REV. C	
APPROVED	<u>1</u>	D3694	
DE APPR.	<u>1</u>	SHEET 4 OF 4	
DATE	08.11.03	TITLE	
		SCALE	
		MOUNTING PLATE ASSY	
		NTS	

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8 7 6 5 4 3 2 1